Work Order ID 65419

January 17, 2011 10:05:34 AM

Item ID: D3825-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Rib Assembly (Basket End)

Start Date: 1/17/11 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 1/20/11 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** CL **Date:** 11/01/17 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3825	Rev A								
100	Large Fab	0.00							
Large Fab		0.00							
Large Fab									

(6) 11-03-01

Memo

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr SAD 11-02-18

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825
A/R S.S. Rod Batch: M114649

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00				Cp 11.03.02			
QC	Memo	0.00							
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00	Sw 03/12			(x6)			
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location:_____	0.00							
Packaging	Basket cell Memo	0.00				AM 11.03.01	(6x)		
Packaging									

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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/03/02

11-03-02

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

January 17, 2011 10:05:33 AM

Work Order ID: 65419

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 1/17/11 **Required Date:** 1/20/11

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	21.0000	1	6	SG	11/02/18	
Spacer Bushing													
				Location			**Loc Qty**		**Loc Code**				
				WA			21						
					58974		1						
					60320		1						
					64048		1						
					64920		18			6x			
D3759-1		Manufactured	No			100	Each	67.0000	1	6	B66489 6x	SG	11.03.01
Bushing													
				Location			**Loc Qty**		**Loc Code**				
				WA			67						
					54072		9						
					64421		16						
					64843		42						
M304TS0.750W.065		Purchased	No			100	f	505.1260	2.125	13.42105	SAD	11-02-18	
304 SQ Tube .75x.75x.065W													
				Location			**Loc Qty**		**Loc Code**				
				MAT			505.126						
					112398		0						
					116267		505.126			13.4211			

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W/O:		WORK ORDER CHANGES					
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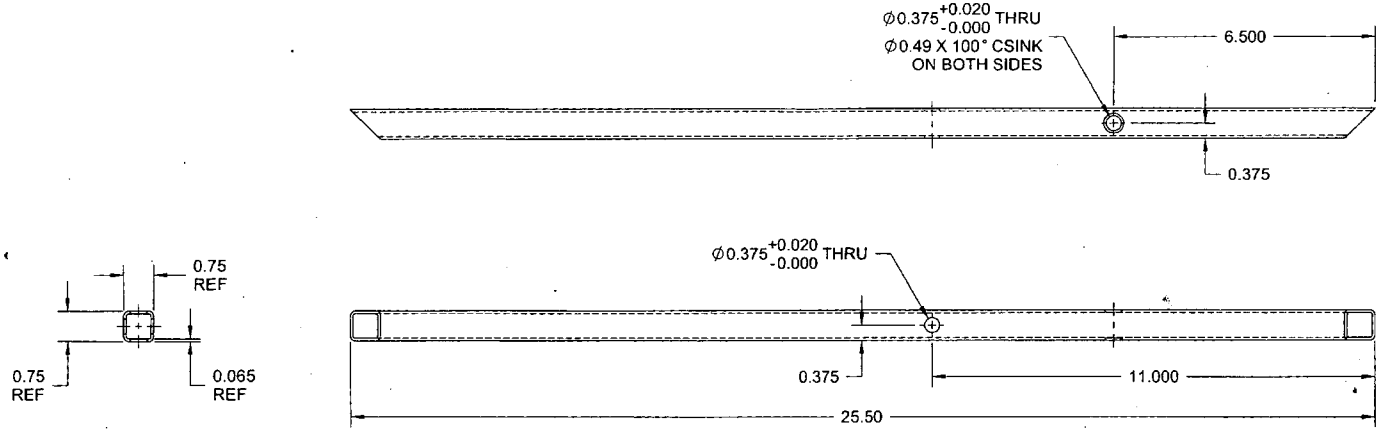

D3825-1 RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65419
CL 11/01/17

RELEASED
08/11/18

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3825 — REV. A — SHEET 3 OF 3
MFG. APPR.		
APPROVED		TITLE: RIB ASSY (BASKET END) — SCALE: NTS
DE APPR.		
DATE	08.09.23	